W	ork C	rder	ID	102906

102906

Page al

June:12-13 9:1	6:29 AM							٠٠, ۲			
Item ID: Revision ID:	D2332-041			Accept	*N900	040	100)* s	etup Stai	t *N	S1*
Item Name:	Lid Prop Asse	mbly 6.69" long	€ ्र ्षे						Sto	*N	S2*
Start Date:	6/11/13	Start Qty: 8.00	*8*		Cust Item I	D:		λ.	• • • • • • • • • • • • • • • • • • •		,`\$
Required Date:	6/11/13	Req'd Qty: 8.00	*8*		Customer:					•	
Reference:	- ·						_	_	G.		y .
Approvals:	Process Pla	in: MCJ	Date: 13-06-1	3 Tooling:	D:	ate:		R	tun Sta	1/1	R1*
\$.	QC:		Date:	SPC (Y/N):	D:	ate:			Sto	*N	R2*
Sequence ID/ Work Center I	D .	Operation Description	, man	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D2332	Rev	C1			÷.						•
100				0.00	\$,						
100				0.00				(8)	-5/	D-13	7-10-28
Small Fab	•	Memo	22 7 and D2222 5 to lond	0.00					,	, ,	
Small Fab			32-7 and D2332-5 to lengt								
			32-11 using 1/2" S.S tubin	ig 7.755 long.				•			
.*	-	3- Deburr.			•						
110	<u> </u>			0.00				<u> </u>		•	_
110				0.00				(8)	_SAD	B-10	½ <u>28</u>
Brake NC		Memo	Form D2332-11 to length s	o.oo os ner dwa D2332 usina D	T8012			_			

(need 2 per ass'y)

DQA:		Date:			1400V 00050 NOV									DART
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RIMANCE / UI		Wor	k Order up	date only	, 7	AEROSPACE
					DISPOSITION				AGAINST I		•			
Work Orde	r:						*		_		,		_	
Part N	o				Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.	En	gineering Quality
NCR N	0				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier		Other
Root				Desci	ription of work order update	1	nitial	Act	ion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification		QC Inspector
Design														
Doc/Data														
quip/Tooling														
Handling/Pre					;									
Material		ļ												!
Operator														
Offset/Setup					•									,
Process														
Supplier	_													
raining														
Fransport		ļ	1											
Jnapproved														
						FAL	ULT CA	regory						
Landin	g Gear				General		-					_	_	
	Bending				Bend		Folio/F	rogram	1	c	outside Dim	ensions	Pres	sure/Forced
	Centre No	ot Conce	ntric		BOM/Route		Grain			c	ver/Under	tolerance	Set-	·up
	Cracks			ļ	Broken/Damage/Defect		Hardwa	ire	<u> </u>	P	art Incorrec	it [Tem	perature/Cure
	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	P	art Lost/Mi	ssing	Wel	d
	Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear	P	art Moved		Wro	ng Stock Pulled
	Crushing				Countersink		Misalig	ned/off center]P	ositioned W	/rong	_	
	Heat Trea	at			Cut Too Short		Mislabe	eled		P	ower Loss/S	Surge	Othe	er
Ĺ	Inspectio	n Strip in	Tube		Drawing		Misread	t	_	_				
	Marks/Cl	natter			Drill Holes		Off-set							
	Turning S	equence			Finish		Out of	Calibration						
	Wave/Tw	ist in Tul	ne .		Fit/Function		Out of	Seguence		_				

Work Orde		02906		*1029	906*							Page 2
Item ID: Revision ID:	D2332-041	sembly 6.69" long		Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1*
Item Name: Start Date: Required Date: Reference:	6/11/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:					IV.	
Approvals:	Process P QC:	lan:	Date:			ite:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I 120 *120* Small Fab Small Fab	D	(drill one pe			Tool ID	Tool #	Plan Code	Accept Qty	Qt	y 1	Reject Number	Insp. Stamp ウー ユオ
130 *130* QC Quality Control		QC5- Inspect part compl Memo	eteness to step on W/O	DAS 27 9-89 5 10 20	Ĭ		j	<u>8</u> 3 10 2	<u></u>			

140

140 Large Fab

Large Fab

0.00

Memo 0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding********

S.S Rod batch: M 125054

8 R 1310-29

DQA:		_ Date:											DART
QA Closed:		Date:			WORK ORDER NON	-CC	ONFOI	RMANCE / UI	PDATE	Wo	ork Order up	odate only	AEROSPACE
Work Orde				į	DISPOSITION				AGAINST		PARTMENT	<u>-</u>	
WORK OTGE	· · · · · · · · · · · · · · · · · · ·				D a v v a mly	ıl		Child Andra 🔲	Connection			10/242212	,
Part N	lo.				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	-	Pro	Water Jet d. Eng. Coor.	Engineering Quality
				_	Use-as-is			noforming	Finishing	-		re/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite	-	, ,	Supplier	
Root				Desci	ription of work order update		nitial	Act	ion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design													
Doc/Data					,								
Equip/Tooling				٠									
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport		ł					,						
Unapproved													
						FAI	ULT CAT	TEGORY					
Landir	ng Gear				General		_						
	Bending				Bend	L	Folio/P	rogram			Outside Dim	ensions	Pressure/Forced
	Centre N	Not Conce	ntric		BOM/Route	L	Grain				Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ct	Temperature/Cure
ļ	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear		Part Moved		Wrong Stock Pulled
	Crushing	_			Countersink		Misalig	ned/off center			Positioned W	Vrong	_
ļ	Heat Tre	eat			Cut Too Short		Mislabe	led			Power Loss/	Surge	Other
	Inspecti	on Strip in	Tube		Drawing		Misread	i					
	Marks/0	hatter			Drill Holes		Off-set						
		Sequence			Finish		Out of 0	Calibration					
	Wave/T	wist in Tul	ne .		Fit/Function		Out of s	Seguence				·	

Work Orde		02906		*102	2906*							Page 3
Item ID: Revision ID:	D2332-041			Accept	*N900	040	100	* 9	Setup S	tart top	*N:	S1*
Start Date: Required Date: Reference:	6/11/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:					*N:	S2*
Approvals:		lan:	Date:			ate:		J		tart Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 150: *150* QC Quality Control 160 *160* QC Quality Control	D	Operation Description QC9- Inspect visual per Memo QC5- Inspect part comp		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code		Reject Qty	л ОІ-	Reject Number	Insp. Stamp DAS 9 SES
170 *170* Small Fab Small Fab		Memo 1- Tumble 2- Assemble	e as per dwg D2332	0.00				8	S.	91. AE 131	3-17-6 111/0	Ó G

DQA:		Date:			MODE ODDED NON	cc	SNEOI	DNAANCE / HDE	DATE					DART
QA Closed:		Date:			WORK ORDER NON		JINFUI	NIVIAINCE / OPL		Vork Or	der up	date only		AEROSPACE
Work Orde	r:				DISPOSITION				AGAINST D	EPARTI	/ENT	PROCESS		
Part N	0				Rework Scrap Use-as-is Suspected Unapproved			Machining noforming	Crosstube Small Fab Finishing Composite	Re		Water Jei d. Eng. Coor e/Packaging Supplie		Engineering Quality Other
Root	,			Descr	iption of work order update		nitial	Actio	n	Sign	1 &			
Cause	Date	Step	Qty		or non-conformance	1	ief Eng	1		Da		Verification	on	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														QC HISPECTO
			<u> </u>	L		FAI	ULT CAT	TEGORY		1				
Landin	g Gear				General									
	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	nk/Ripple at n Strip in aatter equence	e/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	-	Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unquitions Incomplete/Unquitions Incomplete/Unquitions Incomplete/Unquitions Incomplete/Unquition	H-	Over/	Under ncorrectost/Mi loved oned W	ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
1	Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord June-12-13 9:		02906		*10	2906*			Page
Item ID: Revision ID: Item Name:	D2332-041	sembly 6.69" long		Accept	*N900040100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date Reference:	6/11/13 :: 6/11/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID: Customer:			
Approvals:	Process P	'lan:	Date:	Tooling: SPC (Y/N):	Date: Date:	Run	Start Stop	*NR1* *NR2*

Tool ID Tool# Plan Reject Set Up/ Accept Reject Insp. Sequence ID/ Operation Run Hours Number Stamp Code Qty Qty Work Center ID **Description** QC5- Inspect part completeness to step on W/O 180 *180* OC. Memo

0.00

Identify as per dwg & Stock Location 190 *100*

0.00 Memo

Packaging Packaging

QC21- Final Inspection - Work Order Release 200

0.00 Memo

Quality Control

Quality Control

13-11-7 18m 13/11/11 MF 13-11-08

Page 4

DQA:	.	Date:											•	A DT
					WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE					AEROSPACE
QA Closed:		Date:							1	Wd	ork Order up	odate only		
Work Orde	er:				DISPOSITION				AGAINST I	DΕΙ	PARTMENT	/PROCESS		
					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.				Scrap	-		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite [Supplier		
Root				Desci	ription of work order update		nitial	Actio	on		Sign &			
Cause	Dat	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion		Date	Verification	ı	QC Inspector
Design											"			
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material		İ												
Operator														
Offset/Setup	_				,						l i			
Process									•					
Supplier														
Training	_													
Transport	_	1		į										
Unapproved						<u> </u>		<u></u>				<u> </u>		
						FA	ULT CA	TEGORY						
Landii	ng Gear				General	_	1 /-		Г		1	. г		L . :
	Bendi	_		-	Bend	⊢	1	Program	}	_	Outside Dim	<u> </u>		Pressure/Forced
		Not Conce	entric	-	BOM/Route	-	Grain		}		Over/Under			Set-up
	Cracks		- /\41	-	Broken/Damage/Defect	-	Hardwa				Part Incorre	<u> </u>		Temperature/Cure
		/Kink/Rippl	e/wave	-	Burrs	\vdash	1	ion Incomplete/Unc	·		Part Lost/Mi	issing		Weld
	Cuffs Crushi	na		-	Contamination Countersink	\vdash	4	tions Incomplete/Ur	iciear		Part Moved	<u>[</u>		Wrong Stock Pulled
	Heat 1	_			Cut Too Short	\vdash	Mislabe	gned/off center	}		Positioned V			0.5
		reat tion Strip ir	n Tuha	-	Drawing	\vdash	Misrea		L		Power Loss/	ourge [Other
	⊢ ⊣ `	(Chatter	TUDE		Drill Holes	\vdash	Off-set							
		g Sequence	2	-	Finish	\vdash	-	Calibration						
		Twist in Tu			Fit/Function	<u> </u>	4	Sequence				·····		· · · · · · · · · · · · · · · · · · ·
					,	1		1						

Picklist Print

June-12-13 9:16:29 AM

Work Order ID:

102906

Parent Item:

D2332-041

Parent Item Name:

Lid Prop Assembly 6.69" long

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Qty Hand	per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-4A		Purchased	No			170	Each	178.0000	1	2008	12111	1 24	
Bolt										>477	13/"	106	
				Location		Loc Qty	<u>L</u>	oc Code					
				FP001		16							
					1615)187	6 10							
				ST355	7107	162							
					25709	162			(5	?)			
AN960JD416L	NAS1149D0416J	Purchased	No			170	Each	6.0000	3	24	-11		
Washer		1 410114504							<u> </u>	SM.	13/14/8	36	
				Location		Loc Qty	<u>L</u>	oc Code		•			
				FP001		6		244.0		- ∆ (
				110)153	6	•	M126259	6	24			
M304R.250		Purchased	No			100	f	62.4967	0.1	0.84210	53	2	
304 SS Round bar .250									-54	0). 1,5	-10-2	Ŏ	
				Location		Loc Qty	<u>L</u>	oc Code					
				MAT028	4400	62.4967							
	•				1482 <u>)243</u>	5.1 15.6838							
					2682	41.7129			65	3422			
M304TR0.500W.035		Purchased	No			110	f	582.8216	1.25	10.5263			
304 RD Tube .500 x .035\	V									10 13 -	0-28		
				Location		Loc Qty	<u>L</u>	oc Code					
				MAT017		582.82163							
					8702	0.00003							
					5513	151.4645 431.3571				5264			

DQA:			Date:										TOADT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
						Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	lo					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
NCR N	lo					Use-as-is Suspected Unapproved		Thern	noforming Finishing Large Fab Composite	_	Rec/Stor	re/Packaging Supplier	Other
Root					Descr	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance		ief Eng	Description		Date	Verification	QC Inspector
Design			· ·										
Doc/Data										-			
Equip/Tooling									·,				
Handling/Pre													
Material						•							
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved)										
			\				FAI	ULT CA	TEGORY				
Landi	ng Ge	ar				General		_			_		
	В	ending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	c	entre No	t Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	c	racks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct	Temperature/Cure
	c	rimp/Kin	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	c	uffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	c	rushing				Countersink		Misali	gned/off center		Positioned V	Vrong	
	Щн	eat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	lr	rspection	n Strip in	Tube		Drawing		Misrea	d				
	∐∧	1arks/Ch	atter			Drill Holes		Off-set	•				
	Г	urning S	equence			Finish		Out of	Calibration				
	V	Vave/Tw	ist in Tul	oe		Fit/Function		Out of	Sequence				

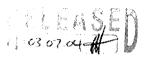
Work Order, ID:	102906	:					
Parent Item:	D2332-041	: *			Start Da	ite: 6/11/13	Required Date: 6/11/13
Parent Item Name:	Lid Prop Assembly 6.69" long				Start Q	ety: 8.00	Required Qty: 8.00
M304TR1.000W.049	Purchased	No		100 f	108.1206	0.43 3.621	0526
04 RD Tube 1.00 x .04	9W						13-10-28
			Location	Loc Qty	Loc Code		
			MAT018	108.12063			
			117598	0.00003			
			120654	18.5309		9/2/5	,
			125250	89.5897		3.6211	
MS21042L4	Purchased	No		170 Each	h 2,576.0000	1 <10 8	12/1/27
Nut						$-\mathcal{OH}$	-13/1//01
			Location	Loc Oty	Loc Code		
			FP001	50			
			122452	38			
			8182	12			
			ST314	1000			
			m125708	1000			
	•		st507	1288			
			125535	1288			;
			ST518	238			
			124231	238	126333	100	

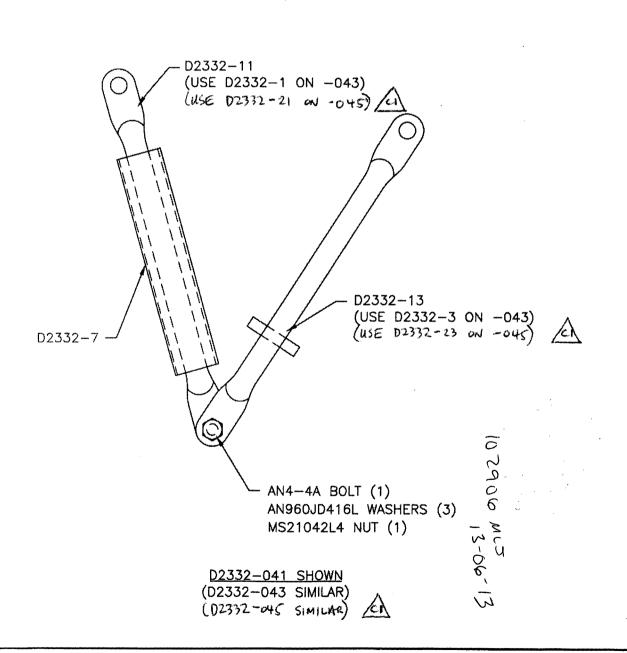
DQA:			Date:										
QA Closed: Date:						WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only							
QA Closed.			Date.				_			VV	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGA	INST DE	PARTMENT	PROCESS	
					_	Rework Skid-tube Cro			Skid-tube Cross	tube	ube Water Jet Engineering		
Part N	lo.					Scrap		!	Machining Small		Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming Finis	hing	Rec/Stor	e/Packaging	Other
NCR N	۱٥					Suspected Unapproved		Large Fab Composi			Supplier Supplier		
Root					Descr	ription of work order update		nitial	Action		Sign &		
Cause	D	ate	Step	Qty		or non-conformance	l	ief Eng	Description		Date	Verification	QC Inspector
Design								, 0					
Doc/Data							Ì						
Equip/Tooling		İ											
Handling/Pre		,											
Material													
Operator .													
Offset/Setup		İ					1						
Process													
Supplier							1						
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Unapproved													
							FA	ULT CA	TEGORY				
Landi					_	General		,			1	_	_
	_	. •			\vdash	Bend	_	1 '	io/Program		Outside Dim	ensions	Pressure/Forced
Centre N			t Concer	ntric	<u> </u>	BOM/Route	<u></u>	Grain			Over/Under	⊢	Set-up
	applier ansport			_	<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorred	⊢	Temperature/Cure
	\vdash	-	k/Ripple	/Wave		Burrs	<u> </u>	1 '	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
					<u> </u>	Contamination	<u> </u>	4	ions Incomplete/Unclear	<u> </u>	Part Moved		Wrong Stock Pulled
 				-	Countersink	<u> </u>	Misaligned/off center		<u> </u>	Positioned V		I	
				-	Cut Too Short	\vdash	Mislabeled			Power Loss/	Surge	Other	
	Inspection Strip in Tube			<u> </u>	Drawing	\vdash	Misread						
	Marks/Chatter			-	Drill Holes	-	Off-set						
	_	-	quence			Finish	<u></u>	4	Calibration			<u> </u>	
Wave/Twist in Tube				oe		Fit/Function	1	Out of :	Sequence				





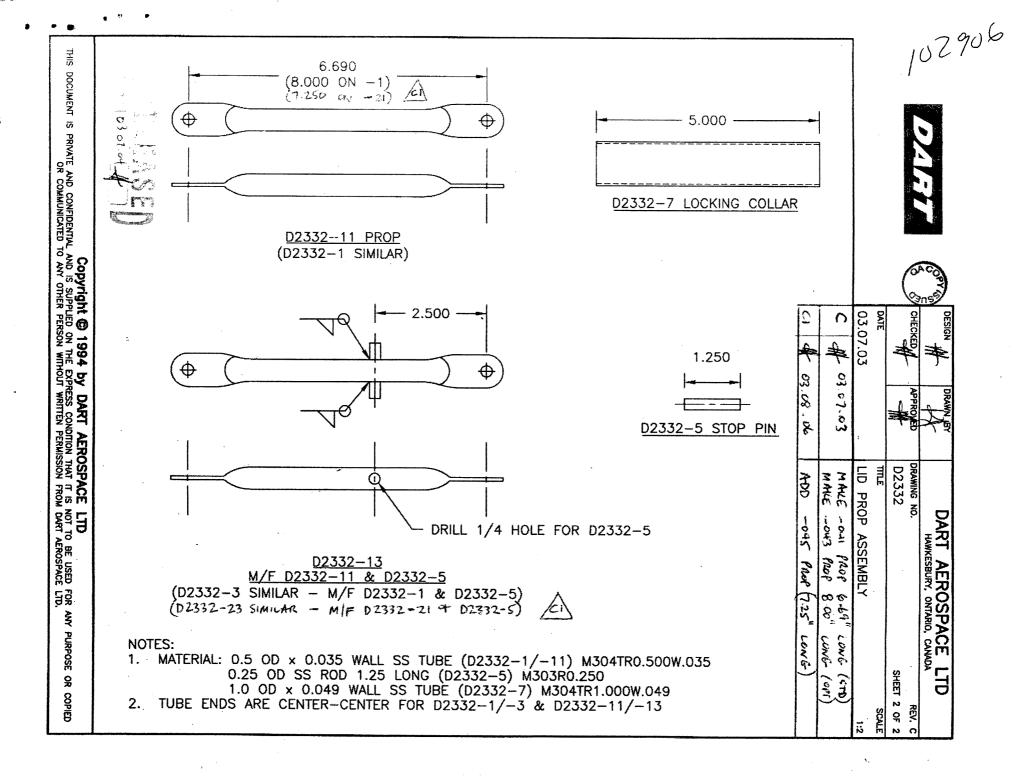
	,								
A	DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
	CHEC	KED	APPROVED	DRAWING NO. REV. C					
"		#	#	D2332 SHEET 1 OF 2					
	DATE			TITLE SCALE					
	03.0	07.03		LOD PROP ASSEMBLY NTS					
	Α		94.12.16	NEW ISSUE					
	В		97.09.30	CHANGE 416 WASHERS TO 416L					
	С	i	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)					
	CI	#4	03 08.06	ADD - 045 PROP (7.25" LONG)					





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DART AEROSPACE LTD



Description: 4 LID	Prop Assemb	V 6.69 600	Work Order:	102 90C
		7		
Inspection Drawing:	332-041	Rev: C7	Part Number:	D2332-041

INSPECTION SHEET

Drawing Dimension	Tolerance				Method of Inspection	Comments
6.690	+/-0.010		V	,==-	measuring tage	SAN-1
2,500	1.0.010		1		measuring to	540-1
5,000	+1-0.016	5.001	<i>\omega</i>		Vern	5AD-1 SFab-08. 3Fab-08
1.250	4-0,016	1,258	/		Vern	Stab - OX
1.0	, ,,,,,					
				-		
i .						
٠. ,					,	
· · · · · · · · · · · · · · · · · · ·						
			 			
<u></u> `						
		<u> </u>				

Measured by: SAD	Checked By:	QC inspector:	Engineering Approval (if necessary):
Date 13-10-28	Date /3/10/28	Date	Date